

ASAP HELP!

Work Order ID 52643

October 5, 2009 2:28:03 PM

Item ID: D3290-041

Accept



Setup Start



Revision ID: C

Stop



Item Name: Replacement Window Assembly

Start Date: 10/05/09 Start Qty: 10.00



Cust Item ID:

Required Date: 10/08/09 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3290

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3290 ( use prog. for D3290-1)

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

18 9-10-6

⑥

FTD

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

18 9-10-6

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

2) 8 02/10/06

④ d

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3290-041 PAR #: \_\_\_\_\_ Fault Category: Prod Eng. Control NCR: (Yes) No DQA: 2 Date: 05.10.14  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 2 Date: 05.10.14

NCR: <u>52643</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
7/10/16	160	DRX was wrong causing 4 notch in hole and oversized it. QH + <del>6</del> Scrap EC Program error	CP 05.10.06 PC QSI 042	Scrap and Destroy And Repla QH + 6 M# 110551	CP 9-10-6	DIP 09/10/13	CP 05.10.06 PC QSI 042	S 02/10/06
			CP 05.10.06 PC QSI 042	- R-X DRX / Program	CP 09.10.07	CP 09.10.07	CP 05.10.06 PC QSI 042	S 02/10/06

NOTE: Date & initial all entries

# Work Order ID 52643

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Item ID: D3290-041

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Setup Start



Revision ID: C

Stop



Item Name: Replacement Window Assembly

Start Date: 10/05/09 Start Qty: 10.00



Cust Item ID:

Required Date: 10/08/09 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

MO 09/10/06

X6

Hand Finishing

140

White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum

0.00



Powdercoat

M112200

Memo

0.00

Powder Coating

START TIME: 2:25  
OVEN TEMPERATURE: 320°  
FINISH TIME: 2:55

MO 09/10/06

X6

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

27 S 09/10/06

(X6) 9/

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID. 52643**

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Item ID: D3290-041

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Revision ID: C

Item Name: Replacement Window Assembly

Start Date: 10/05/09 Start Qty: 10.00

Required Date: 10/08/09 Req'd Qty: 10.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



Small Fab

Small Fab

Small Fab

Memo

Assemble as per Dwg D3290 .Clean D3290-041 and place in plastic wrap

0.00

0.00

SAD 09-10-06

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

DONE ON W/O 52664  
ECN 09-683P

180



Packaging

Packaging

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

Memo

to change  
567-111 see Lndz!

0.00

0.00

W 09-10-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 52643**

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Page 4

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Revision ID: C

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Start Date: 10/05/09 Start Qty: 10.00

Required Date: 10/08/09 Req'd Qty: 10.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

October 5, 2009 2:28:02 PM

Page 1

Work Order ID: 52643

Parent Item: D3290-041RevC

Parent Item Name: Replacement Window Assembly

Comments:

Start Date: 10/05/09

Required Date: 10/08/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2126RevC		Manufactured	No			160	f	497.2000	65.0000			



Seal



SAD 09-10-06

Warehouse	Loc Qty	Loc Code
Location		

Main Warehouse

ST	497.2	
42154	51.7	
48285	445.5	

D3290-3RevC

Manufactured No

160 Each 4.0000 10.0000



Window



78 inch for one part

Warehouse	Loc Qty	Loc Code
Location		

Main Warehouse

ST	4	
47693	4	

M6061T6S.063

Purchased No

100 sf 98.8958 39.4737



6061-T6 .063 Sheet



32.



139-10-6

Warehouse	Loc Qty	Loc Code
Location		

Main Warehouse

MAT	98.89582105	
110551	98.8958211	

110551

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09.10.07	3	MAKE FROM 0.063" MAT'L INSTEAD OF 0.040" See drawing.				 09.10.07 091042	 09.10.07

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

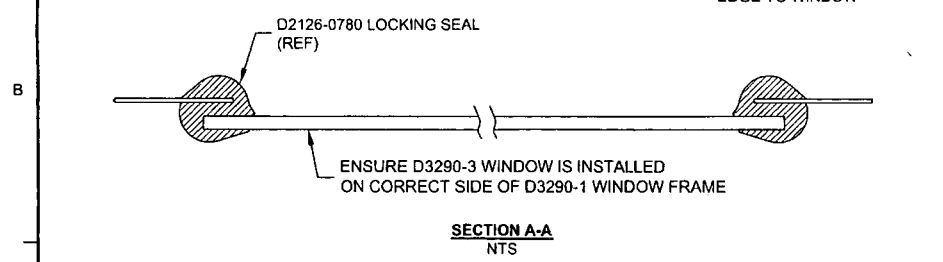
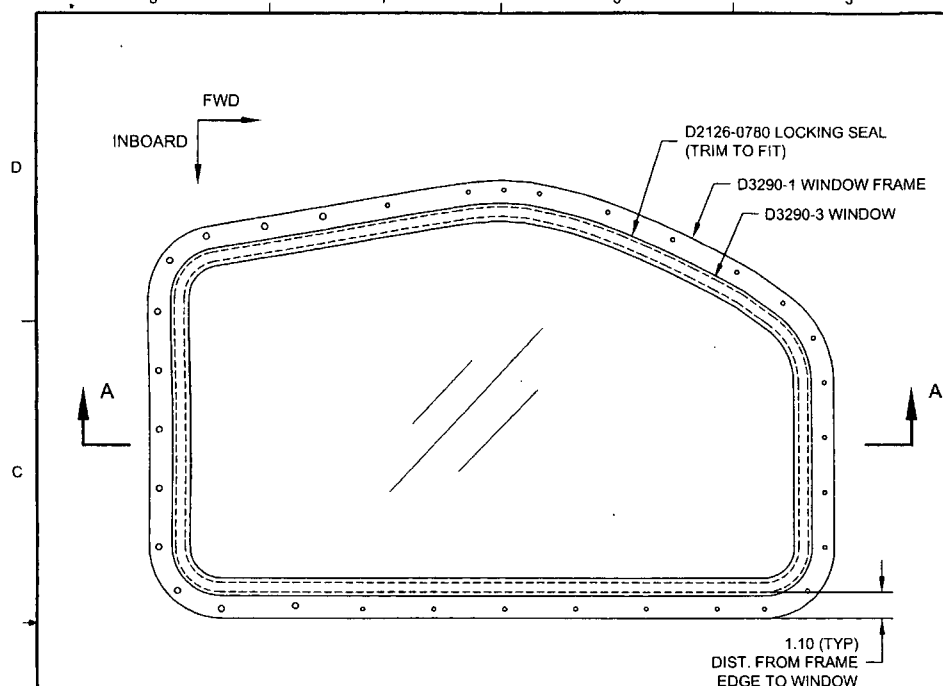
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

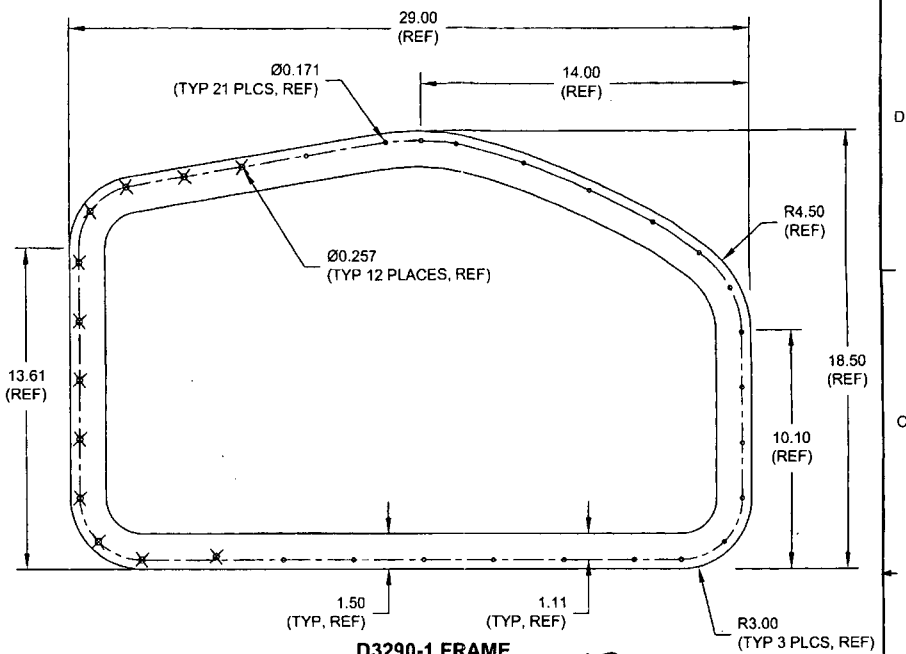
4/052643



**D3290-041 REPLACEMENT WINDOW ASSEMBLY**

**D3290-041 NOTES:**  
1) WEIGHT: 3.66 LBS

**GENERAL NOTES:**  
1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
2) UNITS: INCHES UNLESS OTHERWISE NOTED



**D3290-1 FRAME**

- D3290-1 NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.040) OR 5052-H32 ALUMINUM SHEET 0.040 THICK PER AMS-QQ-A-250/8 OR AMS 4016 (REF. DART SPEC. M5052H32S.040)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1 POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3
  - 3) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 4) IDENTIFICATION: IDENTIFY WITH DART P/N "D3290-1" USING FINE POINT PERMANENT INK MARKER
  - 5) WEIGHT: 0.47 LBS

063  
per GEN 09-6838  
**RELEASED**  
07.09.22

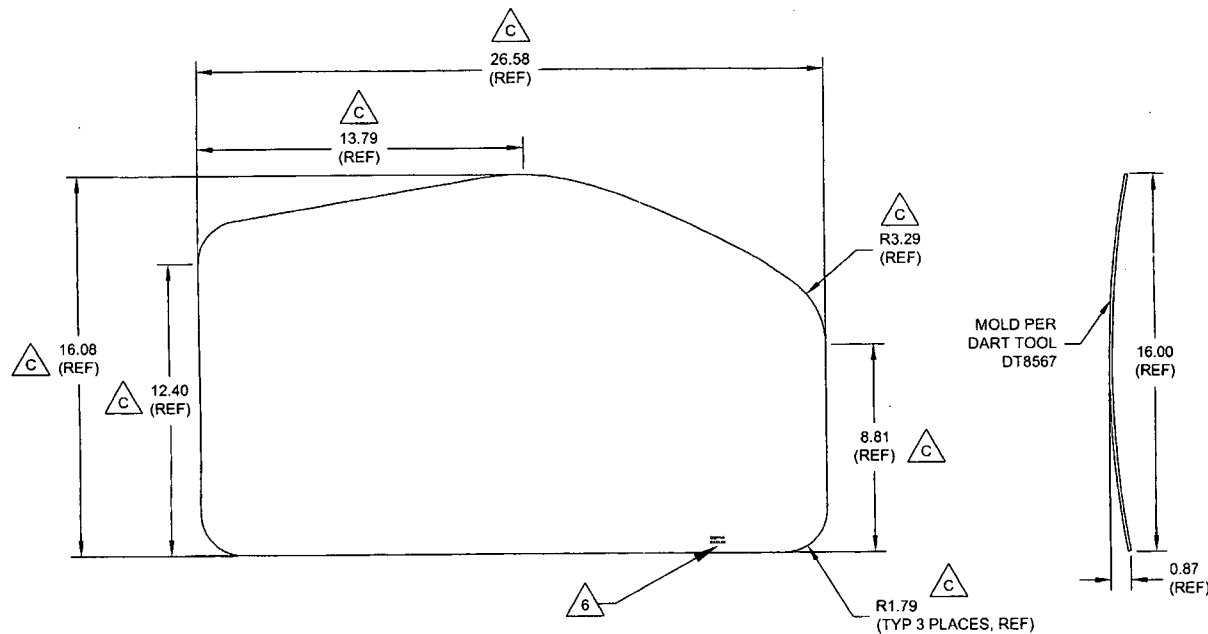
**UNDER REVIEW**  
09.09.18  
MR 09-033

C	UPDATE DIMS PER PAR 188	DC	07.07.24
B	UPDATE MATERIAL PER NCR 029	MB	06.04.20
A	NEW ISSUE	RF	04.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN	BC		
DRAWN	BC		
CHECKED	BC		
MFG. APPR.	BC		
APPROVED	BC		
DE APPR.	BC		
DATE	07.07.24		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3290	REV. C SHEET 1 OF 2
TITLE REPLACEMENT WINDOW ASSEMBLY	
SCALE 1:5	
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no 52643



# **D3290-3 WINDOW**

**UNDER REVIEW**

07.09.18









## **D3290-3 NOTES:**

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425  
OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER  
LP-391 TYPE 1 GRADE C, 0.125 THICK  
(REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE  
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.87 +/- 0.42 LBS
- 8) MOLD PER DART TOOL DT8567

**RELEASED**

07.09.22

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3290	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		REPLACEMENT WINDOW ASSEMBLY 1:5	
DATE	07.07.24	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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